

TODAY 07-05-15

Dart Aerospace Ltd.

Date: Tuesday, 15/05/2007 8:47:24 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ADAPTER
Job Number : 32352
Estimate Number : 12753
P.O. Number : N/A Part Number : D35738
This Issue : 15/05/2007 S.O. No. : N/A Drawing Number : D3573 REV.A
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
Previous Run : 30976 Material : N/A
Written By : Due Date : 15/05/2007 Qty: 12 Um: Each
Checked & Approved By :
Comment : Est Rev:A New Issue 07-01-29 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X02500 6061-T6 Bar .50" x 2.5"



Comment: Qty.: 0.3066 f(s)/Unit Total: 3.6792 f(s)
6061-T6 Bar .50" x 2.5"
Batch: M104366

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blank ~3.250" long

3.500 long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA679 and Dwg D3573

SD 07-05-15

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07-05-15

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 07/05/15

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SD 07-05-15

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/05/2007 8:47:24 AM
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Process Sheet

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Drawing Name: ADAPTER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

211

07-05-15

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/05/15

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

8B

07/05/15

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/16

Job Completion



u 27.05.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

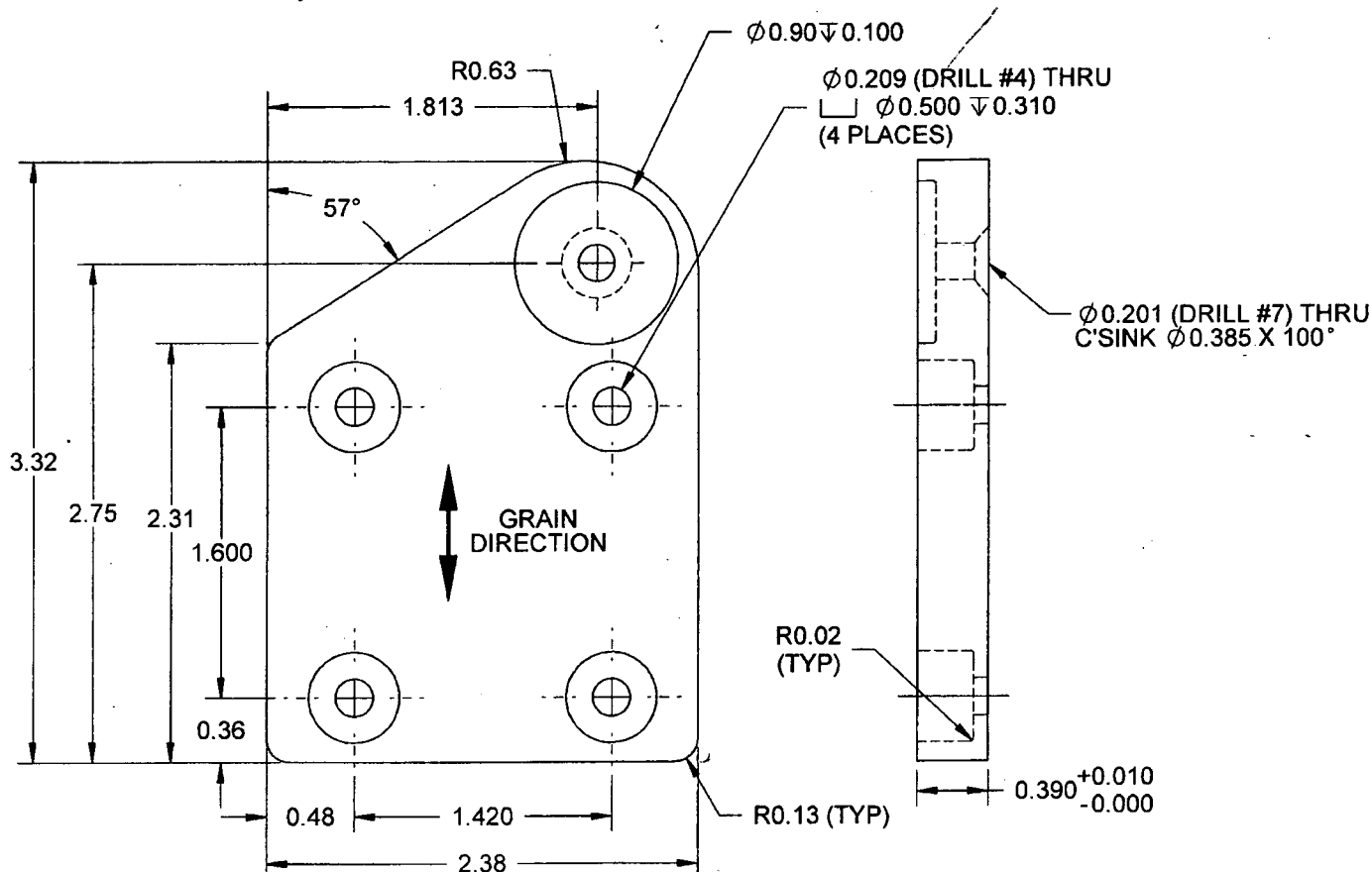
NOTE: Date & initial all entries

W/532352

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19		TITLE ADAPTER	SCALE 1:1

RELEASED
07.04.02



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 32352
Description: ADAPTER		Part Number: D3573-B
Inspection Dwg: D3573 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	$\pm .030$	3.317	/			
2.75	$\pm .030$	2.75	/			
2.31	$\pm .030$	2.31	/			
1.600	$\pm .010$	1.600	/			
.36	$\pm .030$.357	/			
.478	$\pm .030$.478	/			
1.420	$\pm .010$	1.420	/			
2.38	$\pm .030$	2.375	/			
57°		57°	/			
1.813	$\pm .010$	1.810	/			
Ø.90		Ø.900	/			
±.100	$\pm .010$.100	/			
Ø.209		.211	/			
Ø.500		.502	/			
±.310	$\pm .010$.313	/			
Ø.201		.203	/			
C-Sink .385x1.00	$\pm .010$.385x1.00	/			
.390	$\pm .010$.394	/			

Measured by: SA	Audited by: E	Prototype Approval: W/A
Date: 07.05.15	Date: 07/05/15	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	